

Work Order ID 121523

Thursday, June 26, 2014 3:02:19 PM

121523

Page 1

Item ID: D4883-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Fitting

Start Date: 6/26/14

Start Qty: 5.00

5

Cust Item ID:

Required Date: 6/26/14

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-06-27

Tooling:

Date:

QC:

Date:

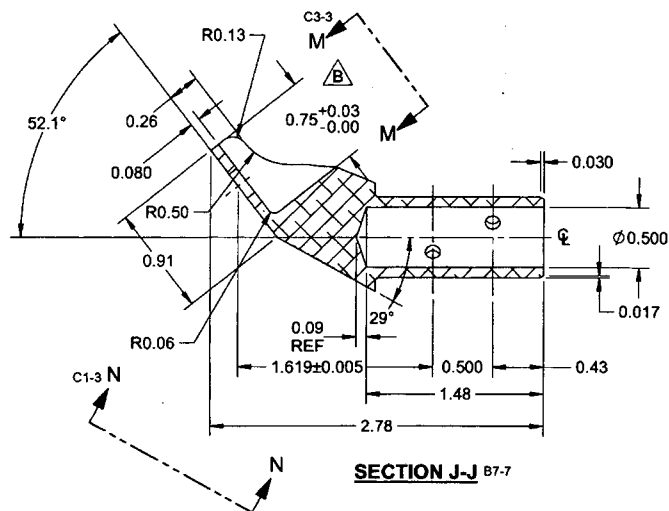
SPC (Y/N):

Date:

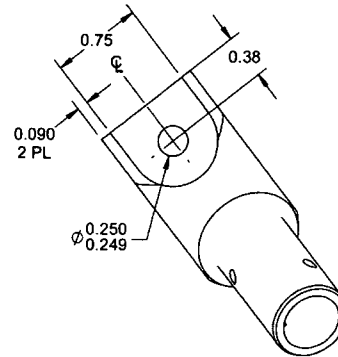
Run Start ***NR1***

Stop ***NR2***

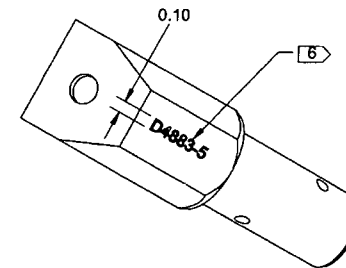
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4883	B								
100	DOOSAN LATHE	0.00				6	Ø		DAS 40 9-89 14/07/09
100									
Doosan	Memo	0.00							
Doosan Lathe	1- Turn as per Dwg. D4883-5 Turning Detail & Folio FB254.								
	2- USE DT10005 For sizing blanks.								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				6	Ø		DAS 40 9-89 14/07/09
110									
QC	Memo	0.00							
Quality Control									
120	HAAS CNC VERTICAL MACHINING #1	0.00							DAS 20 9-89 14-07-14
120									
HAAS 1	Memo	0.00							DAS 02 9-89 14-07-15
HAAS CNC vertical machine #1	1-Machine as per Folio Fb254 & Dwg D4883-5 END FITTING. deburr and Break all sharp edges.								



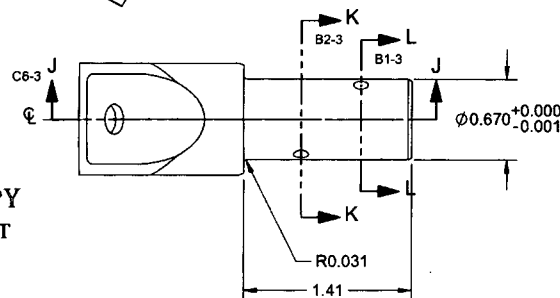
SECTION J-J B7-7



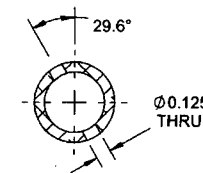
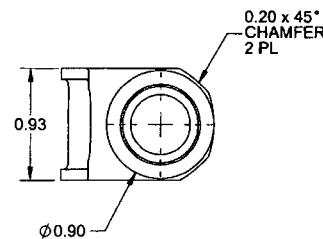
AUXILIARY VIEW M-M D6-3



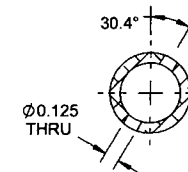
AUXILIARY VIEW N-N C7-3



D4883-5 END FITTING



SECTION K-K B6-3



SECTION L-L B6-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121523 MJS

14-06-27

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.22 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2014-06-16

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D4883	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	END FITTING	NTS
DATE		14.04.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

Page: 1 of 2

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21600	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 25145
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 7 CROSSTUBES + 49 MISC PARTS

ITEM ID: D416-664-203 AFT CROSSTUBE - HIGH
1 - WORK ORDER ID#: 118426

ITEM ID: D206-667-210 AFT CROSSTUBE

2 - WORK ORDER ID#: 120854

3 - WORK ORDER ID#: 120855

4 - WORK ORDER ID#: 120856

5 - WORK ORDER ID#: 120857

6 - WORK ORDER ID#: 120858

7 - WORK ORDER ID#: 120859

ID#: D4883-1 END FITING (QTY 17)

8 - WORK ORDER ID#: 121609

ID#: D4883-7 END FITING (QTY 5)

9 - WORK ORDER ID#: 121409

ID#: D4883-3 END FITING (QTY 15)

10 - WORK ORDER ID#: 121567

ID#: D4883-3 END FITING (QTY 6)


11 - WORK ORDER ID#: 126039

ID#: D4883-5 END FITING (QTY 6)

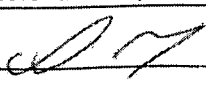

12 - WORK ORDER ID#: 121523

DAS
27
9-89

4/7/25

Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-12) AS PER ASTM1417M-13 NO CRACK FOUND Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018	JUL 24 2014	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp: 	Date: JUL 24 2014
Name: ANTONINO MARCHETTA		